AUTOMOTIVE FINISHES

DTM Primers

2.1 VOC Epoxy Primers

PSE2110 Gray
PSE2120 Black
PSE2130 Off - White

PRODUCT DATA

PRODUCT DESCRIPTION:

2.1 VOC Epoxy Primers, PSE2110/PSE2120/PSE2130, are low VOC, two-component primers offering excellent direct –to –metal adhesion and corrosion resistance over properly cleaned Steel and Aluminum substrates without the use of lead or chromates. 2.1 VOC Epoxy Primers PSE2110/PSE2120/PSE2130 offer flexibility greater than standard epoxy primers. PSE2110/PSE2120/PSE2130 require no induction time and are designed for truck manufacturers, fleets and automotive refinishers where extended service is important. These primers may be topcoated as soon as 30 minutes after priming.

TECHNICAL DATA:

	PSE2110	PSE2120	PSE2130
• Color	Gray	Black	White
• Wt/gallon (mixed)	10.39 lbs/gal	10.27 lbs/gal	10.41 lbs/gal
• Mixing ratio by volume Primer : R7K7210 : PSH2180	6 : 6 : 1	6 : 6 : 1	6 : 6 : 1
• Volume Solids (@ 6:6:1)	37.85%	37.87%	37.93%
• Coverage @ 1 mil (dry)	607	608	609 sq ft/gall
• Pot life @ 70-80°F	2 hr	2 hr	2 hr
• VOC less exempt @ 6:6:1	2.1 lbs/gal	2.1 lbs/gal	2.1 lbs/gal.
• HAPS Status	Compliant, Non-Photochemically Reactive		

• Flash Point (@ 6 : 6 : 1)	38°F Seta
• Viscosity (@ 6:6:1), #2 Zahn cup	14-16 sec.
• Performance after one week air dry (over Aluminum & Steel using GENESIS®)	
- Humidity Resistance - 100 hrs	Pass
- Impact Resistance (direct @ 80 in-lbs)	Pass
- Flexibility (1/8" conical mandrel)	Pass
- Salt Spray Resistance - 250 hrs	Pass
- Gloss Holdout (@ 15 mins re-coat)	Excellent
• Recommended dry film thickness (2 coats)	1.5-2.0 mil

SURFACE PREPARATION:

Bare Substrates: Steel, Galvanized Steel, Aluminum*
**Note: With the inconsistencies of substrates, consult your local SHERWIN–WILLIAMS Representative for system recommendations and substrate testing.*

1. Solvent clean with SHER-WILL-CLEAN® Solvent Cleaner R7K156 or AQUA-MATE™ Low VOC Surface Cleaner W4K157 and wipe dry with a clean, dry cloth.
2. Mechanically abrade all bare metal. For hot-rolled steel, a media blast is required to remove any surface impurities.
3. Solvent clean with SHER-WILL-CLEAN® Solvent Cleaner R7K156 or AQUA-MATE™ Low VOC Surface Cleaner W4K157 and wipe dry with a clean, dry cloth. For hot-rolled steel, proceed to primer application.

(For the above products refer to the appropriate product label or data page for complete information.)

Prepainted Substrates:

1. Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean, dry cloth.
2. Solvent clean surfaces with UltraClean® Surface Cleaner R7K158, SHER-WILL-CLEAN® Solvent Cleaner R7K156 or AQUA-MATE™ Low VOC Surface Cleaner W4K157. Wipe dry with a clean, dry cloth.
3. Grind repair area to remove paint and all rust as needed. Fill as needed using an appropriate body filler. Allow body filler to tack up and shape as needed.
4. Sand repair area and featheredge using 80, 180, 280, and finish with 320 grit treated sandpaper on a random orbital sander. Solvent clean to remove sanding residue before recoating.

MIXING:

1. Shake 2.1 VOC Epoxy Primers PSE2110/PSE2120/PSE2130 thoroughly before mixing.
2. Mix by volume 6 parts 2.1 Epoxy Primer PSE2110/PSE2120/PSE2130 to 6 part R6K7210 Reducer to 1 part 2.1 Epoxy Activator PSH2180. *Note: For a quicker dry and for smaller units/areas VS100 may be used. For increased temperatures ES20 maybe used for improved overspray acceptance.*
3. Stir thoroughly and strain.

APPLICATION:

1. For proper results use the following equipment recommendations. Check equipment by applying PSE2110/PSE2120/PSE2130 Epoxy Primer to a test panel before using.
2. Apply 2 wet coats of PSE2110/PSE2120/PSE2130 Epoxy Primer to achieve the recommended dry film thickness of 1.5-2.0 mils.

DRYING SCHEDULE:

Dry times are based on the recommended dry film thickness of 1.5-2.0 mils.

- Air dry times @ 75°F and 25% R.H.

Hand-slick	5 minutes
To Recoat	30 minutes (see below)
Tack-Free	1 hour
Nib Sandable (220-320 grit)	1 hour
Sandable/Feather edge (400 grit)	3 hrs
Tape Free	6 hrs

- Force dry times (to tape free)

45 minutes at 160°F
30 minutes at 180°F

RECOMMENDED GUNS:

Spray Gun Type & Model	Manufacturer	Fluid Tip/ Needle	Air Cap	Atomizing Air	Fluid Delivery	Gun Distance
HVLP (M21)	Kremlin	#209 (.035)	LP3	10 psi at cap	10-12 oz/min	4-6 inches
HVLP (GTI)	DeVilbiss	1.4 mm	#100	10 psi at cap	10-12 oz/min	4-6 inches
HVLP (K-NR 95)	SATAjet	NR-95 (.0895)	NR-95 (.08)	10 psi at cap	10-12 oz/min	4-6 inches
Pressure Feed (JGA 502)	DeVilbiss	FF or FX	797/777	50-55 at gun	10-12 oz/min	10-12 inches

RECOATING:

1. PSE2110/PSE2120/PSE2130 2.1 VOC Epoxy Primers may be recoated up to 3 days after spraying without scuffing for all topcoats except for Ultra 7000®, which may be recoated up to 2 days without scuffing. When 3 days have passed, scuff sand with 320 grit or finer sandpaper to insure proper adhesion.
2. Recommended topcoats:

DIMENSION™ 3.5 Urethane
ULTRA ONE-STAGE TURBO®
ULTRA 7000® Basecoat/Clearcoat
ACRYLYD® 5.0
ACRYLYD® H.S.
SUNFIRE® Acrylic Urethane
SUNFIRE® Low VOC Acrylic Urethane
SUNFIRE® Basecoat/Clearcoat
GENESIS® 2.8/3.5 Acrylic Urethane
GENESIS® Basecoat/Clearcoat

PRODUCT AT-A-GLANCE

PRODUCT **2.1 VOC Epoxy Primers**

PSE2110	**Gray**
PSE2120	**Black**
PSE2130	**Off-White**

USE

- Direct to properly cleaned metal surfaces
- Ideal for harsh environments where corrosion protection is important
- Fast dry

SUITABLE SUBSTRATES

- Steel*
- Galvaneal/Galvanized Steel*
- Aluminum*

* See previous page for details

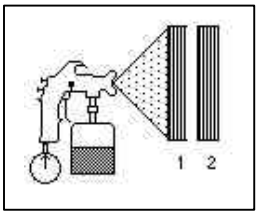
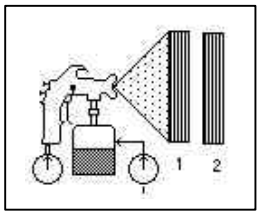
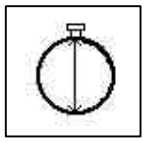
SURFACE PREPARATION

- Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with clean cloth.
- Solvent clean with the appropriate solvent cleaner, and wipe dry with a clean cloth.
- Grind repair area to remove paint and all rust as needed.
- Apply body filler to clean bare metal as needed.
- Sand all areas to be refinished and featheredge all broken film areas.

MIXING

1. Stir or shake 2.1 VOC Epoxy Primer PSE2110/PSE2120/PSE2130 thoroughly before mixing.
2. Mix by volume 6 parts 2.1 Epoxy Primer PSE2110/PSE2120/PSE2130 to 6 parts R7K7210 Reducer to 1 part 2.1 Epoxy Activator PSH2180. *Note: For a quicker dry and for smaller units/areas VS100 may be used. For increased temperatures ES20 maybe used for improved overspray acceptance.*
3. Stir thoroughly and strain.

APPLICATION

Siphon Feed	Pressure Feed	Time to Recoat
Apply 2 coats.	Apply 2 coats.	30 minutes
Allow each coat to become hand slick.	Allow each coat to become hand slick.	
		
50 - 55 psi HVLP: 8-10 psi	50-55 psi pot pressure: 8-10 psi	

RECOAT

SUNFIRE® Acrylic Urethane	DIMENSION™ 3.5 Urethane
SUNFIRE® Low VOC Acrylic Urethane	ULTRA 7000® Basecoat/Clearcoat
SUNFIRE® Basecoat/Clearcoat	ACRYLYD® HS
GENESIS® 2.8/3.5 Acrylic Urethane	ACRYLYD® 5.0
GENESIS® Basecoat/Clearcoat	ULTRA ONE-STAGE TURBO®

NOTES

- Scuff sand with 320 or finer sandpaper after 3 days of dry time before topcoating.
- For optimum corrosion resistance, 1.5-2.0 mils of primer (dry) is recommended.

PERSONAL PROTECTION

- Read all label directions before use.
- Refer to MSDS for specific information.
- Wear a NIOSH approved organic vapor respirator when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety glasses, coveralls, and rubber gloves when using product.

PRODUCT DATA

Cleveland, OH 44115

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AS2470
07/01